

Work Order ID 84765

84765

Page 1

July-06-12 10:26:25 AM

Item ID: D206-667-207BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Mid Aft

Start Date: 5/23/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/08/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-247	A (DEO)								
IIN-D206-667	D								

100

100

DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile and create labels as per PPP D206-667-207 chg 002

110

110

BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-207

SCRAP

W/O: 84705		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-207B PAR #: _____ Fault Category: Landing gear / cross tube NCR: Yes No DQA: 12/08/13 Date: 12/08/13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12/08/14 Date: 12/08/14

NCR: 12-1670		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/13	# 110	During the Bendig & take. Bore in central Bend. at Program 10	OK 12/08/03 PST 042	- SCRAP 1 Dosty qty x1	MO 12/8/7	JW 12-8-7	12/08/03 PST 042	DAS 16 9-83 12/08/13

NOTE: Date & initial all entries

84765

July-06-12 10:26:25 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/23/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/08/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____, **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84765***84765***

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July-06-12 10:26:25 AM

Item ID: D206-667-207BL Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Mid Aft
Start Date: 5/23/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/08/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Crosstubes

0.00

Crosstubes

Memo

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 and drill table DT8577 and tower holes #6 as per QS10010 and as per Dwg D206-667-247. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT 8584 & DT8583 as per Dwg D206-667-247. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247

6-Drill Fwd rivet holes using drill Jig DT8787 as per Dwg D206-667-147. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT 8787 as per Dwg D206-667-247.

8-C'sink holes as per Dwg D206-667-247.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-247 Inside of Cuff(Donot engrave on outside of tube)

10 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84765

July-06-12 10:26:25 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/23/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/08/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-247

140	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

140

QC

Quality Control

Memo

0.00

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

150	0.00
-----	------

150

HandFXtube

Hand Finishing Crosstubes

Memo

0.00

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

1- CLEAN CROSSTUBE WITH WASH'N WIPE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84765***84765***

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July-06-12 10:26:25 AM

Item ID: D206-667-207BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Mid Aft

Start Date: 5/23/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/08/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1 Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	0.00 0.00							
180 *180* Packaging Packaging Packaging	Packaging Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.	0.00 0.00							
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure results are as per Dwg D206-667-247	0.00 0.00							

Work Order ID 84765***84765***

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July-06-12 10:26:25 AM

Item ID: D206-667-207BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Mid Aft

Start Date: 5/23/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/08/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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195

0.00

195

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

1- PRESSURE WASH AND THEN USE WASH'N WIPE TO CLEAN
CROSSTUBE BEFORE CHEMICAL CONVERSION

197

QC7-Inspect Chemical Conversion Coat

0.00

197

QC

Memo

0.00

Quality Control

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

Page 7

Wrap in plastic bag to protect from scratches

84765

July-06-12 10:26:25 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/23/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/08/12 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 84765***84765***

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July-06-12 10:26:25 AM

Item ID: D206-667-207BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Mid Aft

Start Date: 5/23/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/08/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-207

Location: _____

PPP Rev: _____

Work Order ID 84765***84765***

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July-06-12 10:26:25 AM

Item ID: D206-667-207BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Mid Aft

Start Date: 5/23/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/08/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MCJ 12/08/08
closed at zero

Picklist Print

Page 1

May-23-12 7:26:42 AM

Work Order ID: 84765

Parent Item: D206-667-207BL

Parent Item Name: Crosstube Mid Aft

Start Date: 5/23/12

Required Date: 6/08/12

Start Qty: 1.00

Required Qty: 1.00

Comments: RevA 11.01.13 New Issue EC verified by:DD
615 DD VERF:EC

IPP REV:B 11.08.08 PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A Bolt		Purchased	No			250	Each	216.0000	10	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		216							
				118191		80							
				121181		36							
				121243		100							
AN5-32A Bolt		Purchased	No			250	Each	268.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST339		168							
				119328		3							
				119862		50							
				120423		75							
				120910		30							
				121415		10							
				ST340		100							
				121541		100							
AN5-34A Bolt		Purchased	No			250	Each	64.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				339		25							
				121181		25							
				ST339		39							
				120422		39							
AN960JD516 Washer	NAS1149D0563J	Purchased	No			250	Each	0.0000	18	18			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-23-12 7:26:42 AM

Page 2

Work Order ID: 84765

Parent Item: D206-667-207BL

Parent Item Name: Crosstube Mid Aft

Start Date: 5/23/12

Required Date: 6/08/12

Start Qty: 1.00

Required Qty: 1.00

D206-667-247TRN
Crosstube Assembly, Mid Aft

Manufactured No

110 Each 3.0000 1 1

Location

Loc Qty

Loc Code

LG

3

78498

1

83300

1

83301

1

D2873-043
Nut Plate Assembly

Manufactured No

220 Each 44.0000 2 2

Location

Loc Qty

Loc Code

LG052

44

72644

2

81502

2

82949

40

D2873-045
Nut Plate Assembly

Manufactured No

220 Each 37.0000 2 2

Location

Loc Qty

Loc Code

LG052

37

81425

2

82947

35

D2892-1
Support

Manufactured No

230 Each 31.0000 2 2

Location

Loc Qty

Loc Code

LG

12

79222

12

82110

5

LG052

19

79888

14

MO 12-7-11

May-23-12 7:26:42 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 84765

Parent Item: D206-667-207BL

Parent Item Name: Crosstube Mid Aft

Start Date: 5/23/12

Required Date: 6/08/12

Start Qty: 1.00

Required Qty: 1.00

D3595-063-450
RUBBER CUSHION

Manufactured No

230 Each 85.8095 4 4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	68	
82511	68	
LG051	7.7	
80161	7.7	
MAT052	10.109474	
67353	2	
68893	6	
70113	0.56	
71354	0.2	
74113	0.349474	
75597	1	

MS20601-AD4W10
RIVET

Purchased No

220 Each 218.0000 14 14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG050	217	
120676	17	
121690	100	
125125	100	
LG051	1	
118675	1	

May-23-12 7:26:42 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-23-12 7:26:42 AM

Page 4

Work Order ID: 84765

Parent Item: D206-667-207BL

Parent Item Name: Crosstube Mid Aft

Start Date: 5/23/12

Required Date: 6/08/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No 250 Each 1,521.0000 4 4
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
300	500	
121652	500	
ST300	1021	
108827	8	
116105	5	
116548	43	
117611	18	
119109	939	
17651	8	

MS21920-22 Purchased No 230 Each 56.0000 4 4
Clamp(per MIL-DTL-8783C)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	1	
119545	1	
LG050	55	
116207	7	
117506	1	
118186	8	
120631	39	

May-23-12 7:26:43 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

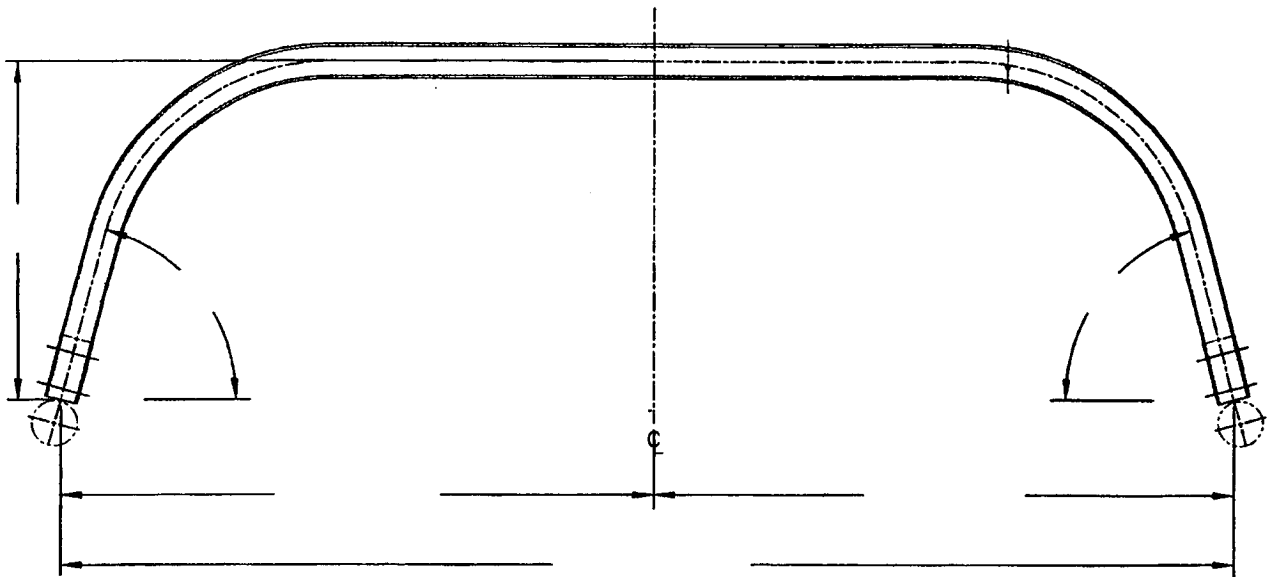
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84765
Description: Crosstube Mid Aft (206L)		Part Number:	D206-667-207
Inspection Dwg: D206-667-247 Rev: A			Page 1 of 1

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	N/A
Crushing	N/A	6%



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

DEO ATTACHED

SCW #11-615
11.07.28

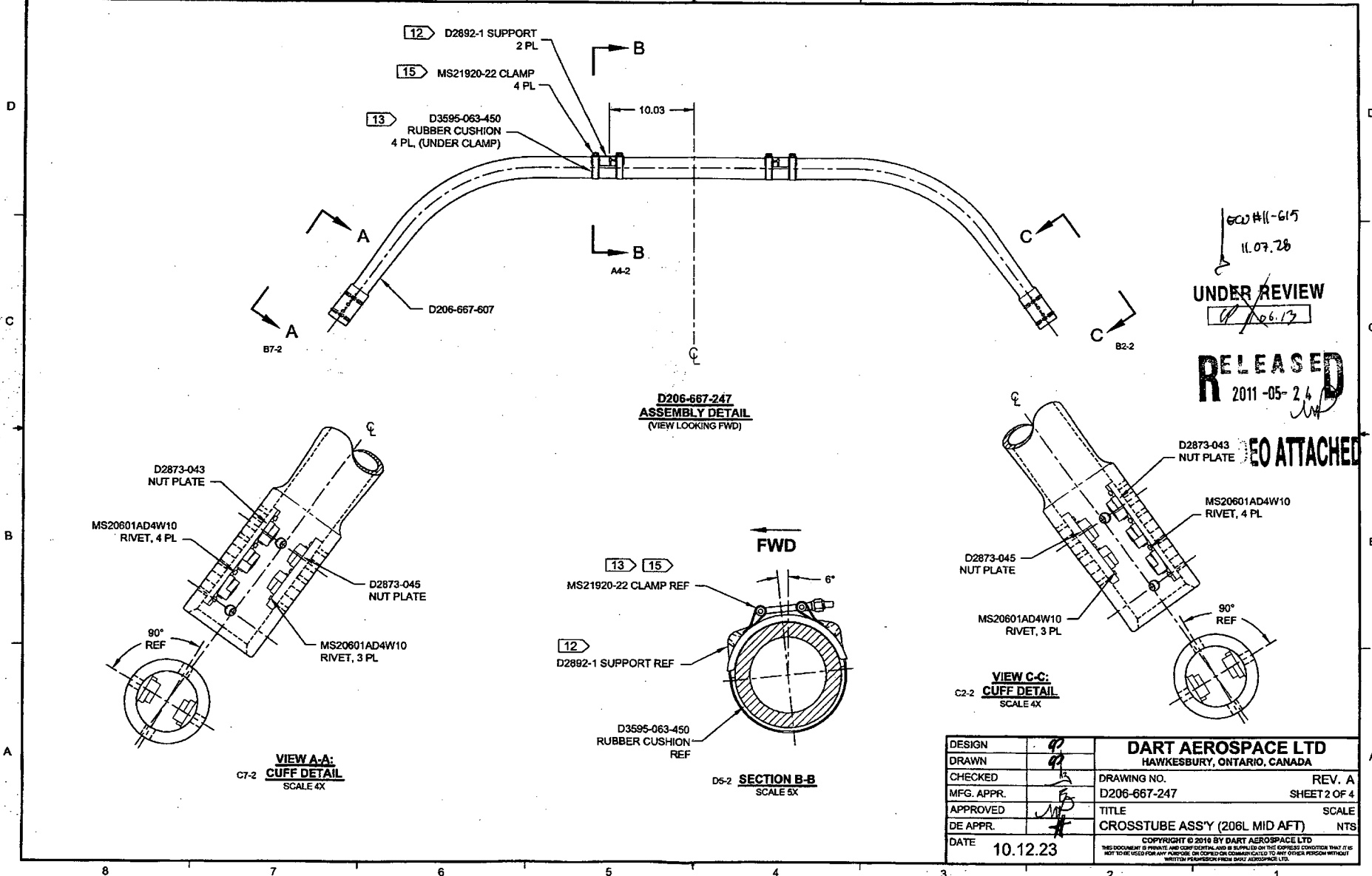
UNDER REVIEW

RELEASED
2011-05-24

A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	97		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-247	REV. A SHEET 1 OF 4
TITLE CROSSTUBE ASS'Y (206L MID AFT)	SCALE NTS
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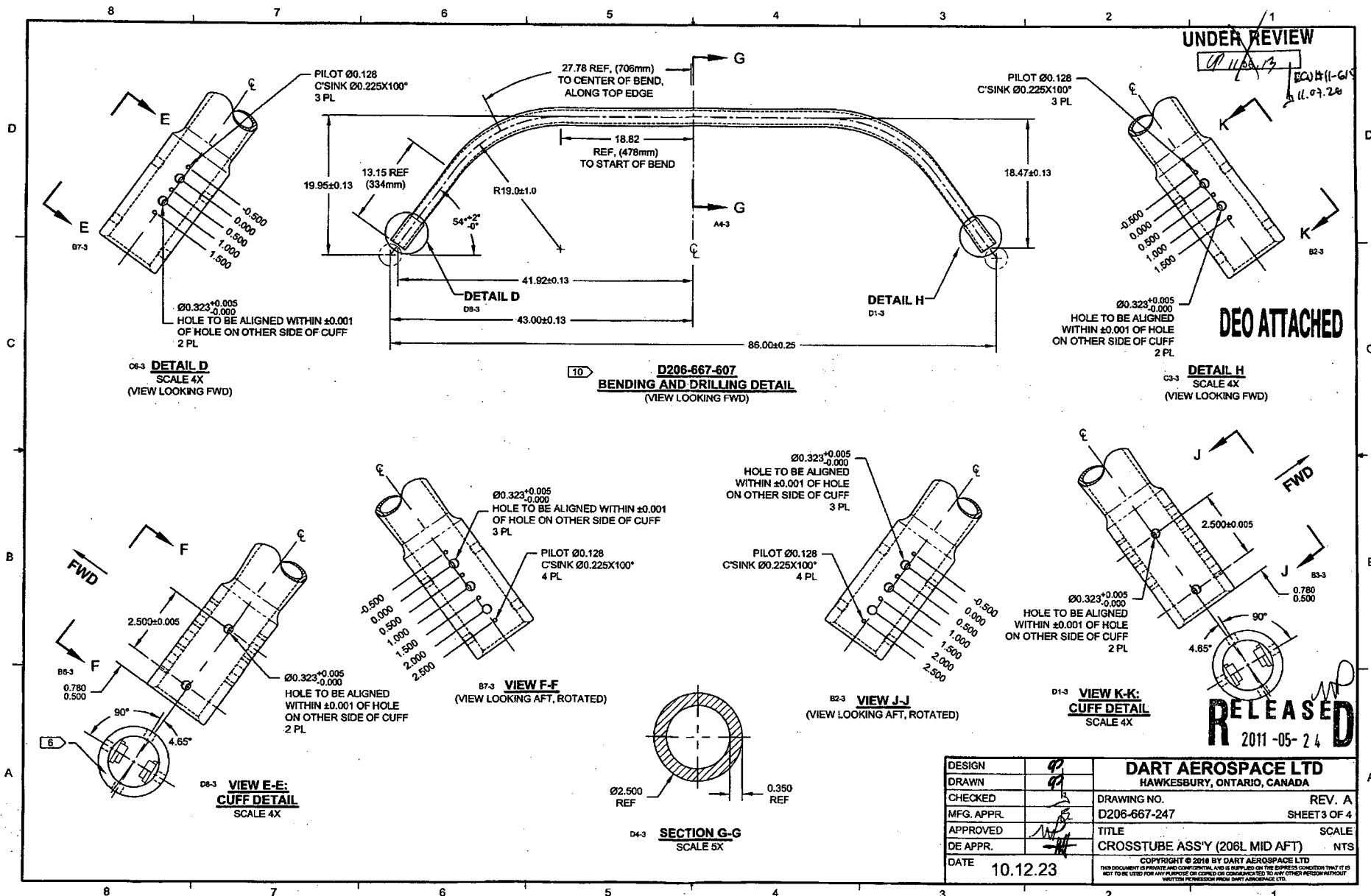
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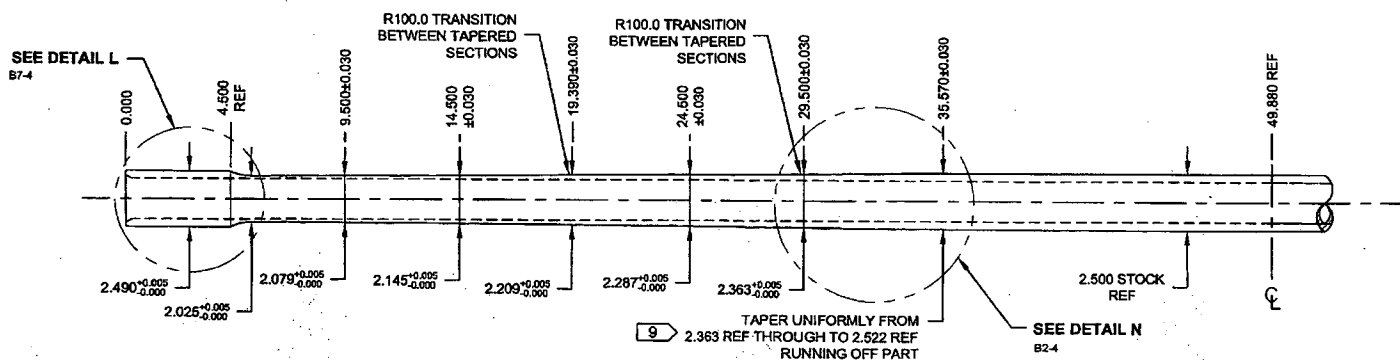
600 #11-615
11.07.28
UNDER REVIEW
10.06.13

RELEASED
2011-05-24
EO ATTACHED

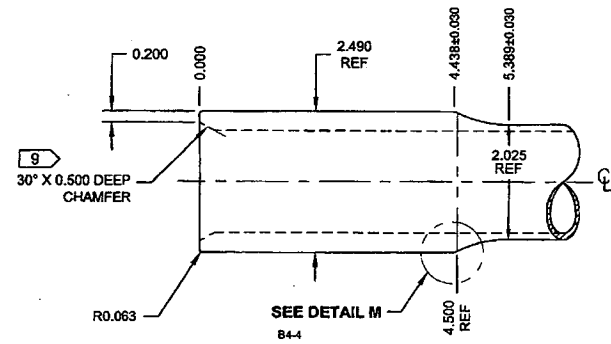
DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. A
MFG. APPR.	13	D206-667-247	SHEET 2 OF 4
APPROVED	13	TITLE	SCALE
DE APPR.	13	CROSSTUBE ASSY (206L MID AFT)	NTS
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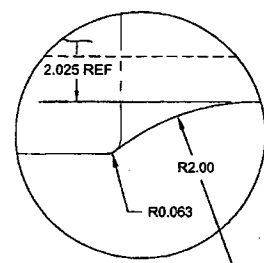
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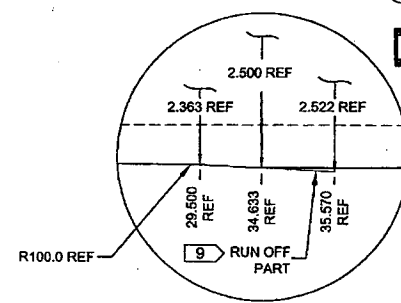
TURNING DETAIL



C7-4 **DETAIL L: CROSSTUBE CUFF**
SCALE 2.5X



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

BCW #11-615
11.07.26
UNDER REVIEW
11.06.13

DEO ATTACHED

RELEASED
2011-05-24

DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	9	D206-667-247	SHEET 4 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DRAWING NO. D206-667-247	TITLE CROSSTUBE ASS'Y (206L MID AFT)	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-247-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>KD</i>	APPROVED <i>WMD</i>	DE APPR. <i>H</i>			
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.7.21			

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL

CHANGE:

IS:

Item	Qty -247	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WMD

